

# CORIAN® QUARTZ ALABASTER TERRAZZO FABRICATION

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## Introduction

Corian® Quartz Alabaster Terrazzo has large particles of quartz that can impact fabrication. This fabrication bulletin addresses specific fabrication guidelines for Corian® Quartz Alabaster Terrazzo. This guidance augments the general quartz fabrication guidelines provided in K-30216 *Corian® Quartz Design*.

## Overview

Alabaster Terrazzo has large, randomly distributed particles of quartz, which has some inherent variability that could lead to chipping at higher cutting speeds. While DuPont has had success cutting Alabaster Terrazzo, results may vary with equipment condition, vibration, etc. that can affect outcome when conditions are less than ideal equipment and cutting conditions. This bulletin provides slower cutting conditions as a starting point, increase speed if no chipping occurs.

### A. Bridge Saw

Following best practices with well-maintained equipment will aid in obtaining quality results. The cutting substrate should be flat and in good position to minimize movement of the slab during cutting.

Use a quality blade designed for cutting quartz that is in good condition, using abundant fresh water when cutting.

When cutting Alabaster Terrazzo for the first time the suggested starting speed is 0.8 m/min (31"/min.). With positive results this rate can be increased in small increments. If chipping occurs reduce the cutting speed.

For fabricators with variable RPM saws, increasing the blade tip speed (RPM x Blade Circumference) by 15-30% may also aid in a quality cut.

Rinse slab surface after cutting and dry, don't allow to air dry, as it can be difficult to remove water spots.

### B. Water Jet

As typical for cutting with a water jet, the quality of the cut decreases with increased speed. Adjust speed to achieve desired finish for later fabrication steps.

### C. CNC Cutout and Holes

Make sure the slab is well supported to minimize movement during cutting. Clean suction cups prior to use to ensure a good hold. Place suction cups near the cut. Make sure the cutout is well supported by suction cups, so it does not move towards completion of the cutout. Use plenty of fresh water when cutting.

The recommended starting speed for routing a cutout is 0.4 m/min. (16"/min.). With positive results speeds can be increased. Reduce speed if chipping occurs.

For cutting holes, 2500 RPM is recommended for small holes, 2000 RPM for holes large.

Rinse slab surface after cutting and dry, don't allow to air dry, as it can be difficult to remove water spots.

### D. Reference

K-30216 *Corian® Quartz Design*

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